

Date: Wednesday, 5/10/2006 9:19:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 27049B		Part Number	: D2512		
Estimate Number	: 10193		Drawing Number	: D2512 REV D2		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/10/2006 S.O. No. : N/A		Drawing Revision	: D2		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/30/2006		
Previous Run	: 27048B		Qty:	1 Um: Each		
Written By	: See J. Comment Below					
Checked & Approved By	: J. 06.05.10					
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF		Est Rev:N 06.04.05	Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
		Pick: 3/4"x3/4" 304/316 SS tube .063" wall 19.58	23.58
		Batch: M100783 185"+50" M100748 92"+190"	106/05/17
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D3166-3 Basket Hoop B25896	106/05/17
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D2506 Label Plate B26631	106/05/17
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		2 D2327-1 Bushing B26742	106/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Drawing Name: 350/212/130 BASKET LID

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Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2232-1 Hinge plate

B25238

M 06/05/24

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2581 Mounting Bracket

B26204

M 06/05/24

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M100981

M 06/05/24

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.
EC130 Basket only

Pick:

Qty Part Number Description

Batch

2 D2012-117 Clevis

M 06/05/24

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350/212/130 BASKET LID

Job Number: 27049B

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Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-05-24

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/29 (1)

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M100652

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① P 06/06/01

Job Completion



W 06/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QA: N/C Closed: _____ Date: _____



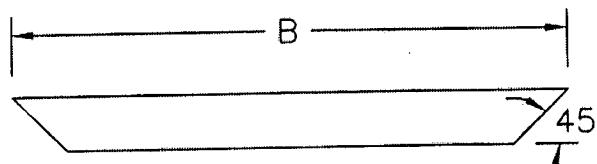
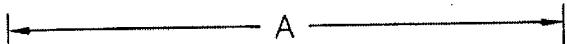
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

RELEASED
01.04.27 *HP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	CP 03.01.20	ADD D2012-117 FOR D130-701-041
D2	CP 04.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

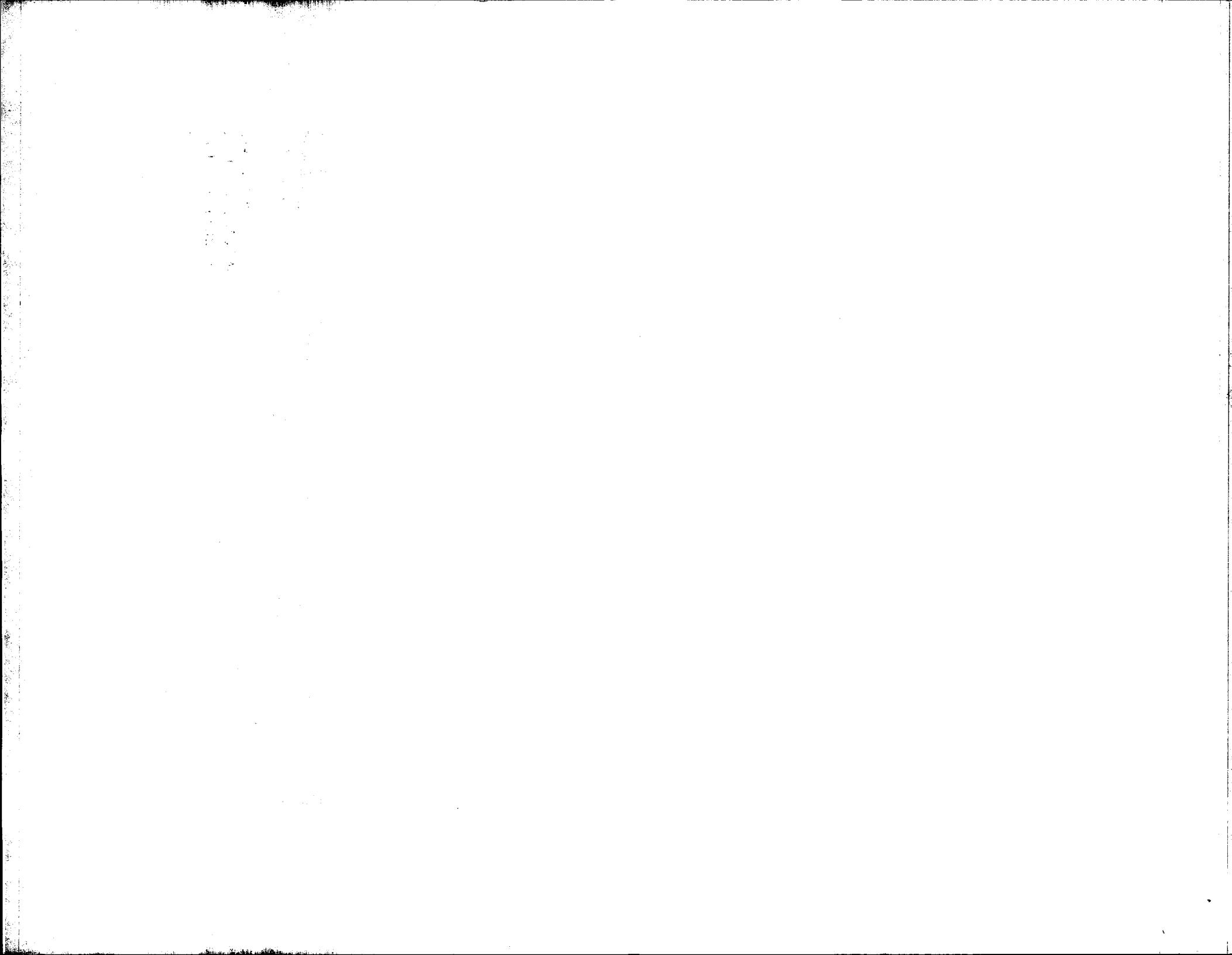
ALL DIMENSIONS ARE IN INCHES

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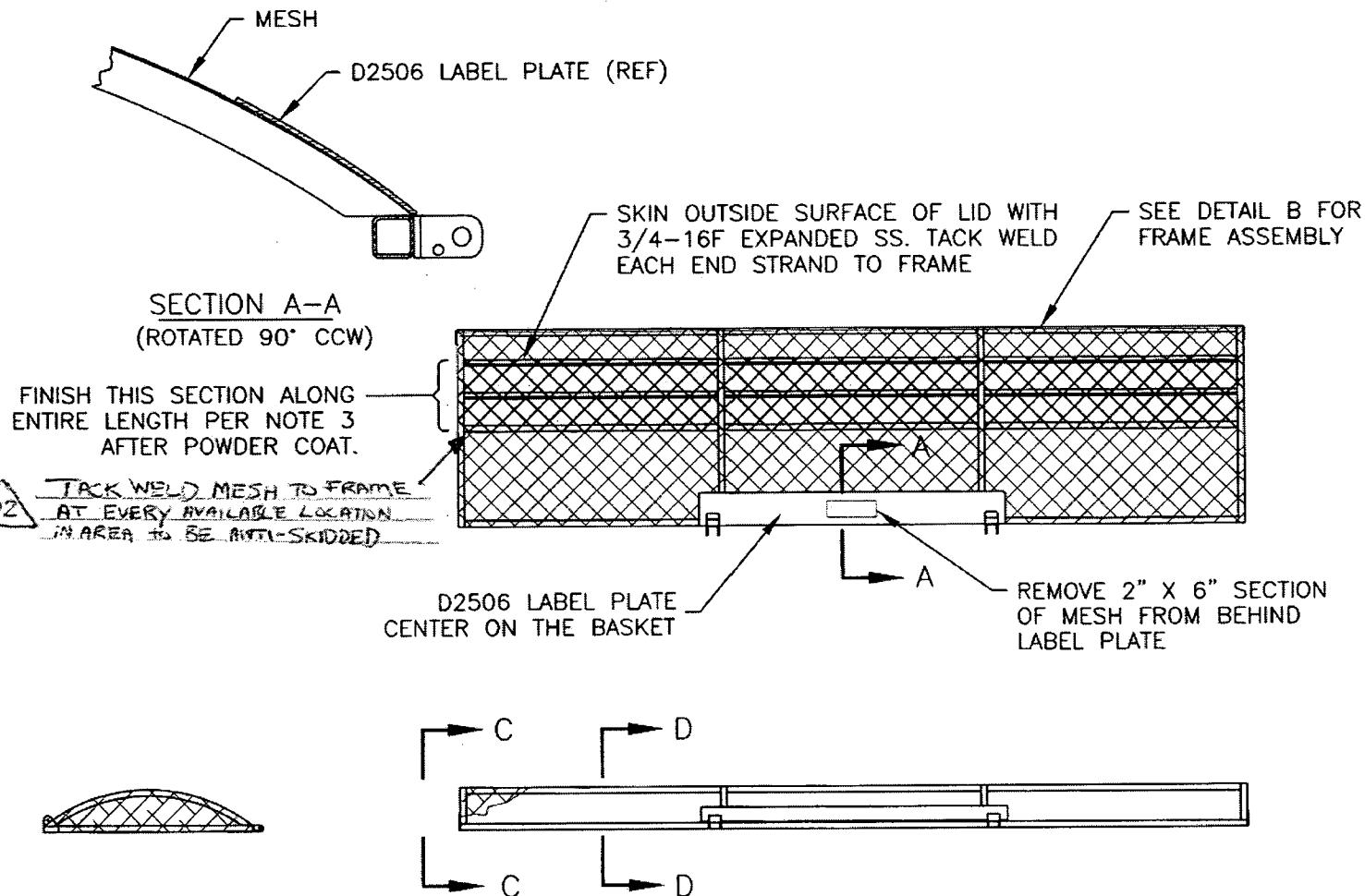


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D2512 BASKET LID ASSEMBLY

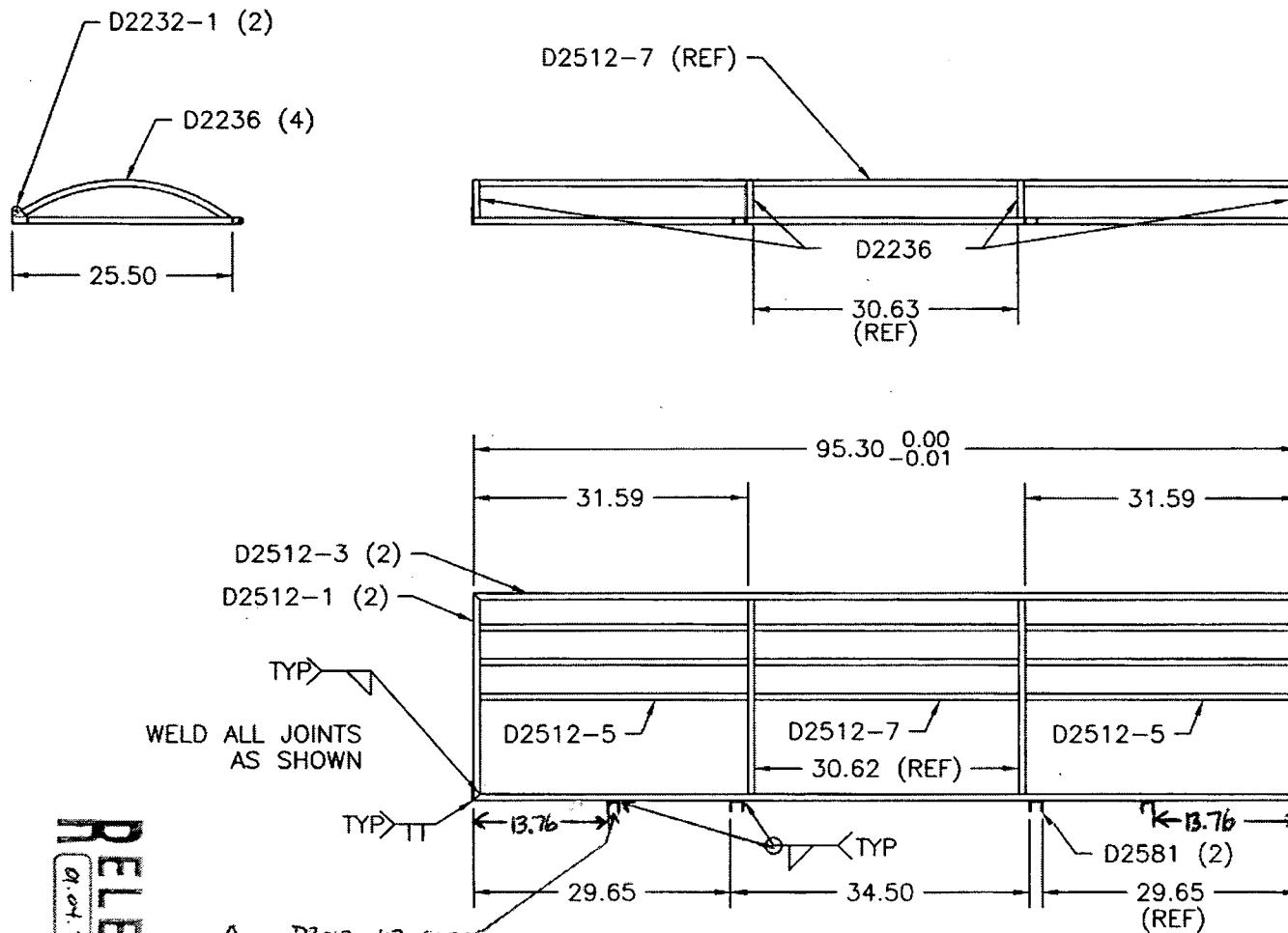
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



DESIGN	BW	DRAWN BY	DART AEROSPACE LTD	
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DATE		DRAWING NO. D2512		SHEET 2 OF 4
01.04.19		TITLE		SCALE 1:20
BASKET LID ASSEMBLY (350/212)				

DART

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DATE 01.04.19	DRAWING NO. D2512	REV. D
TITLE BASKET LID ASSEMBLY (350/212)	SHEET 3 OF 4	SCALE 1:20



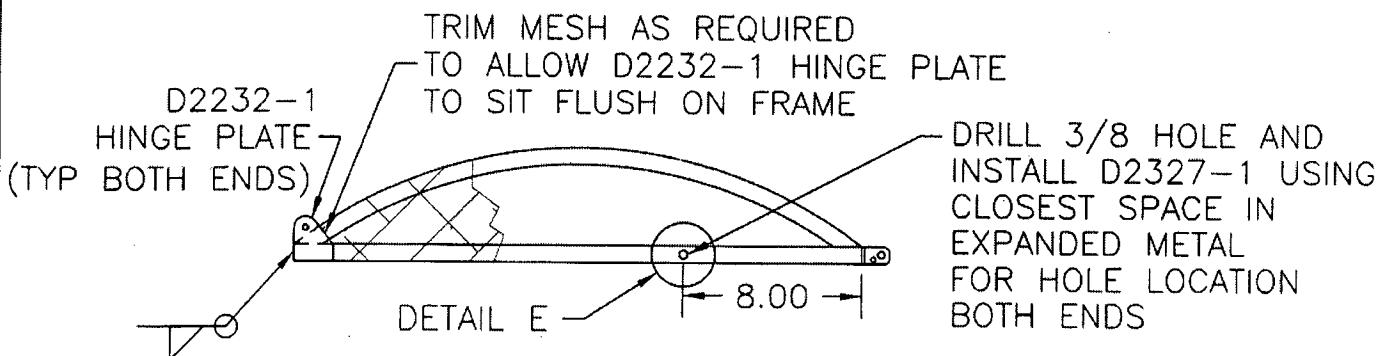
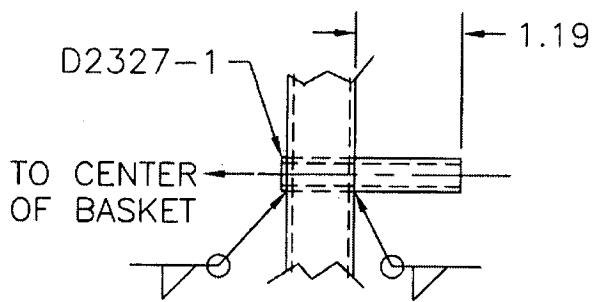
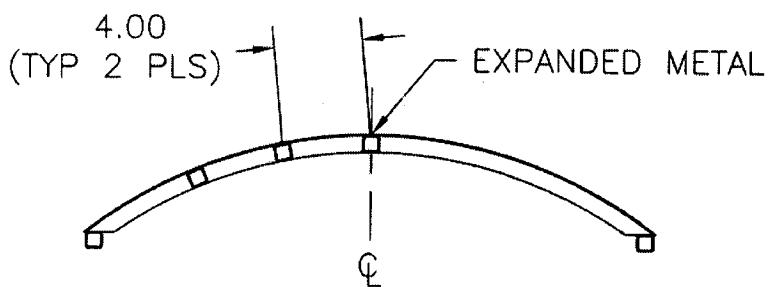
DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

SECTION C-C SIMILIAR BOTH END RIBSDETAIL ESECTION D-D SAME BOTH CENTER RIBS

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